



UNITED STATES ENVIRONMENTAL PROTECTION AGENCY
REGION 5
77 WEST JACKSON BOULEVARD
CHICAGO, IL 60604-3590

OCT 07 2016

REPLY TO THE ATTENTION OF

CERTIFIED MAIL 7009 1680 0000 7647 3460
RETURN RECEIPT REQUESTED

Mr. David Graf
Director of Operations
Seville Flexpack Corporation
9905 South Ridgeview Drive
Oak Creek, Wisconsin 53154

Re: Notice of Violation
Compliance Evaluation Inspection
EPA ID Number: WID091783647

Plant 1
9905 South Ridgeview Drive
Oak Creek, Wisconsin 53154

Plant 2
9941 South Ridgeview Drive
Oak Creek, Wisconsin 53154

Dear Mr. Graf:

On June 21, 2016, a representative of the U.S. Environmental Protection Agency inspected the Seville Flexpack Corporation ("SFC") facility located in Oak Creek, Wisconsin. As a large quantity generator of hazardous waste, SFC is subject to the Resource Conservation and Recovery Act, 42 U.S.C. § 6901 et seq. (RCRA). The purpose of the inspection was to evaluate SFC's compliance with certain provisions of RCRA and its implementing regulations related to the generation, treatment, and storage of hazardous waste. A copy of the inspection report is enclosed for your reference.

Based on information provided by SFC, on EPA's review of records pertaining to SFC, and on the inspector's observations, EPA has determined that SFC has unlawfully stored hazardous waste without a license or interim status as a result of SFC's violation of certain requirements for a license exemption under Wis. Admin. Code § NR 662.034(1)-(3). EPA has identified the license exemption requirement(s) violated by SFC as of the date of the inspection in paragraphs 1- 7 below.

Also, EPA has determined that SFC violated RCRA requirements related to universal waste as described in paragraph 8, below.

STORAGE OF HAZARDOUS WASTE WITHOUT A LICENSE OR INTERIM STATUS

At the time of the inspection, SFC violated the following large quantity generator license exemption requirements:

1. Hazardous Waste Container Start Dates

A large quantity generator must ensure that the date upon which each period of accumulation begins is clearly marked and visible for inspection on each container. See, Wis. Admin. Code § NR 662.034(1)(b) [40 C.F.R. § 262.34(a)(2)].

At the time of the inspection the following 90-day storage containers were not marked with start dates of accumulation:

- In Plant 1, two 55-gallon drums of “Dirty Solvent” and “Ink Waste,” respectively, located in the distillation room.
- In Plant 2, two 55-gallon drums of “Dirty Solvent.”

The wastes in these containers may have been awaiting reclamation in a distillation unit; however, the waste that is to be reclaimed before reuse is spent and must be managed as a hazardous waste. Also, these containers were not at or near their respective points of generation and were, therefore, not satellite accumulation containers as asserted by SFC representatives.

2. Hazardous Waste Container and Tank Labeling Requirements

A large quantity generator must ensure that containers and tanks holding hazardous waste are labeled with the words “Hazardous Waste.” See, Wis. Admin. Code § NR 662.034(1)(c) [40 C.F.R. § 262.34(a)(3)].

At the time of the inspection the following 90-day storage containers and tank were not labeled with the words “Hazardous Waste.”

- In Plant 1, two 55-gallon drums located in the distillation room, as identified in item 1, above. These containers were marked only as “Dirty Solvent,” and “Ink Waste,” respectively.
- In Plant 2, four 55-gallon drums in the 90-day storage area in the distillation room were marked only with the words, “Ink Waste,” “Dirty Solvent” (two drums), or “Adhesive Waste.” As mentioned above, these drums also were not at or near the point of generation, and were not satellite containers.
- In Plant 2, a tank (“Plant 2 Tank”) used for interim storage of spent solvents generated from cleaning the presses prior to distillation was not marked with the words “Hazardous Waste.”

3. Hazardous waste Tank System Requirements – Subchapter J

A large quantity generator, in accordance with Wis. Admin. Code § NR 662.034(1)(a)2. [40 C.F.R. § 262.34(a)(1)(ii)], must comply with the following requirements, among other things, for new above-ground tank systems installed after March 1, 1991, which are used to store hazardous waste:

- Obtain a written assessment reviewed, and certified by a qualified professional engineer attesting that the tank system has sufficient structural integrity and is acceptable for storing and treating hazardous waste. See Wis. Admin. Code § NR 665.0192(1) [40 C.F.R. § 265.192(a)];
- Use an independent, qualified installation inspector or a qualified Professional Engineer to inspect the new tank system or component in use for (1) weld breaks; (2) punctures; (3) scrapes of protective coating; (4) cracks; (5) corrosion; (6) and other structural damage or inadequate construction or installation. See Wis. Admin. Code § NR 665.0192(2) [40 C.F.R. § 265.192(b)];
- Test the new tanks and ancillary equipment (e.g., piping and pumps used to distribute hazardous waste from its point of generation to a storage or treatment tank) for tightness prior to being covered, enclosed, or placed in use. See, Wis. Admin. Code § NR 665.0192(4) [40 C.F.R. § 265.192(d)];
- Ensure that ancillary equipment is supported and protected against physical damage and excessive stress due to settlement, vibration, expansion or contraction. See Wis. Admin. Code § NR 665.0192(5) [40 C.F.R. § 265.192(e)];
- Obtain and keep on file at the facility written statements by those persons required to certify the design of the tank system and supervise the installation of the tank system in accordance with the requirements in Wis. Admin. Code § NR 665.0192(2) – (6) [40 C.F.R. § 265.192(b) – (f)]. See Wis. Admin. Code § NR 665.0192(7) [40 C.F.R. § 265.192(g)];
- Provide secondary containment with a leak detection system for the tank systems that store or treat materials that become hazardous waste. Please note, tanks systems include ancillary equipment. See Wis. Admin. Code § NR 665.0193 [40 C.F.R. § 265.193]; and
- Inspect, at least once per operating day, data gathered from leak detection equipment, overfill/spill control equipment, the above-ground portions of the tank system, and the construction materials and the area immediately surrounding the tank system, including the secondary containment system to detect erosion (including cracks and gaps) or signs of releases of hazardous waste. See, Wis. Admin. Code § NR 665.0195(1) and (2) [40 C.F.R. § 265.195(a) and (b)]. These inspections must be documented in an operating log. See Wis. Admin. Code § NR 665.0195(7) [40 C.F.R. § 265.195(g)].

At the time of the inspection, SFC was not managing the Plant 2 Tank as a hazardous waste storage tank. SFC did not conduct the above-listed required activities and/or failed to provide to EPA the attendant documentation.

4. Air Emission Standards for Equipment Leaks – Subchapter BB

In accordance with Wis. Admin. Code § NR 662.034(1)(a)2. [40 C.F.R. § 262.34(a)(1)(ii)], a large quantity generator who uses a tank system to store hazardous waste with organic concentrations of at least 10 percent by weight, must determine the applicability of Wis. Admin. Code chapter 665, subchapter BB [40 C.F.R. part 265, subpart BB] for air emission leaks from equipment associated with that tank system. Equipment is defined under Wis. Admin. Code § NR 664.1031 [40 C.F.R. § 264.1031] to mean each valve, pump, compressor, pressure relief device, sampling connection system, open-ended valve or line, or flange or other connector, and any control devices or systems required by this subchapter.

At the time of the inspection, SFC was not managing the Tank 2 Plant as a hazardous waste storage tank. SFC had not determined the applicability of subchapter BB for the equipment associated with this tank.

5. Air Emission Standards for Tanks – Subchapter CC

In accordance with Wis. Admin. Code § NR 662.034(1)(a)2. [40 C.F.R. § 262.34(a)(1)(ii)], a large quantity generator who uses a tank system to store hazardous waste with an average volatile organic concentration of at least 500 parts per million by weight, must determine the applicability of Wis. Admin. Code chapter 665, subchapter CC [40 C.F.R. part 265, subpart CC] for air emission standards for the tank. Under Wis. Admin. Code § NR 665.1090(2) [40 C.F.R. § 265.1090(b)], the generator who uses air emission controls in accordance with Wis. Admin. Code § NR 665.1085 [40 C.F.R. § 265.1085] shall prepare and maintain records of compliance.

At the time of the inspection, SFC was not managing the Plant 2 Tank as a hazardous waste storage tank; however, the Plant 2 Tank was vented to a regenerative thermal oxidizer to control emissions. Though SFC was using Level 2 controls for the Plant 2 Tank, SFC had not determined the applicability of subchapter CC for the tank, and therefore, had not prepared records of compliance.

Note: During the inspection, SFC representatives posited that Plant 2 Tank, which is associated with a distillation unit, is excluded from RCRA regulation per the “closed loop” exemption under Wis. Admin. Code § NR 661.04(1)(h) [40 C.F.R. § 261.4(a)(8)]. This exemption states, in part, that “Secondary materials that are reclaimed and returned to the original process or processes in which they were generated where they are reused in the production process...” are not solid wastes. The secondary material must be used and reused in a production process. The act of cleaning the equipment, albeit a necessary step for high quality output, is not considered by EPA as part of the production process, and therefore does not qualify for this exemption. Also note that the exemption includes the following provision: “...the entire process through completion of reclamation is closed by being entirely connected with pipes or other comparable enclosed means of conveyance.” Wastes identified as “Dirty Solvent” in 55-gallon drums are also introduced into the reclamation system via external pumps. These wastes are not piped into the system, and further nullifying the use of this particular exemption at SFC.

6. Personnel Training

A large quantity generator of hazardous waste must do the following, *inter alia*, with respect to personnel training:

- Maintain documentation of the job title and job description for each position at the facility related to hazardous waste management, and the name of each employee filling that job. See, Wis. Admin. Code § NR 665.0016(4)(a) and (b) [40 C.F.R. § 265.16(d)(1) and (2)];
- Provide an annual review of the hazardous waste management and contingency plan training required in Wis. Admin. Code § NR 665.0016(1) [40 C.F.R. § 265.16(a)]; See, Wis. Admin. Code § NR 665.0016(3) [40 C.F.R. § 265.16(c)]; and,
- Maintain records of annual hazardous waste management and contingency plan training. See, Wis. Admin. Code § NR 665.0016(4)(d) [40 C.F.R. § 265.16(d)(4)].

At the time of the inspection, records were not available to review for personnel training within the most recent three years. SFC representatives stated that each individual who physically manages hazardous waste had been trained initially; however, annual reviews of that training had not been conducted. The representatives also noted that the training program was enhanced with the assistance of WDNR inspector Walter Ebersohl after his inspection at the Facility in 2008. Job descriptions for employees whose job duties are related to hazardous waste management, including, but not limited to, personnel who conduct weekly inspections, prepare waste for off-site shipment, and are the emergency coordinators for the site, were not available for review.

7. Weekly Inspections

A large quantity generator of hazardous waste must inspect, at least weekly, the areas where containers holding hazardous waste are stored. See, Wis. Admin. Code 662.034(1)(a)(i); 665.0174 [40 CFR §§ 262.34(a)(1)(i); 265.174].

At the time of the inspection, SFC was storing two 55-gallon drums of “Dirty Solvent” and “Ink Waste,” respectively, in the distillation room. Weekly inspections were not being conducted in this area, as it was assumed to be a satellite accumulation area. See item 1, above.

Summary of license exemption requirements: By violating the requirements for a license exemption, above, SFC became an operator of a hazardous waste storage facility, and was required to obtain a Wisconsin hazardous waste storage license. SFC failed to apply for such a license. SFC’s failure to apply for and obtain a hazardous waste storage license violated the requirements of Wis. Admin. Code §§ NR 680.30, 680.31, and 680.32 [40 C.F.R. §§ 270.1(c), and 270.10(a) and (d)].

UNIVERSAL WASTE VIOLATION

8. Under Wis. Admin. Code § NR 673.14(1) and (5) [40 C.F.R. § 273.14(a) and (e)], a small quantity handler of universal waste must label or clearly mark each lamp or a container or package in which such lamps are contained with any one of the following phrases: "Universal Waste-Lamps," "Waste Lamps" or "Used Lamps."

At the time of the inspection, SFC was storing six boxes of lamps for recycling in the warehouse in Plant 1. These containers were not marked as delineated above.

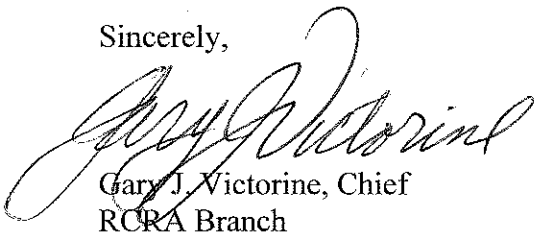
CONCLUSION

At this time, EPA is not requiring SFC to apply for a Wisconsin hazardous waste storage license so long as it immediately establishes compliance with each of the requirements for a permit exemption outlined in the paragraphs, above.

According to Section 3008(a) of RCRA, EPA may issue an order assessing a civil penalty for any past or current violation, requiring compliance immediately or within a specified time period, or both. Although this letter is not such an order or a request for information under Section 3007 of RCRA, 42 U.S.C. § 6927, we request that you submit a response in writing to us no later than 30 days after receipt of this letter documenting the actions, if any, which you have taken to establish compliance with all outstanding requirements listed above. You should submit your response to Brenda Whitney, U.S. EPA, Region 5, 77 West Jackson Boulevard, LR-8J, Chicago, Illinois 60604.

If you have any questions regarding this letter, please contact Ms. Whitney, of my staff, at 312-353-4796 or at whitney.brenda@epa.gov.

Sincerely,



Gary J. Victorine, Chief
RCRA Branch

Enclosure

cc: Dolores Hayden, WDNR (Dolores.Hayden@wisconsin.gov)
Michael Ellenbecker, WDNR (Michael.Ellenbecker@wisconsin.gov)

UNITED STATES ENVIRONMENTAL PROTECTION AGENCY
REGION 5
77 WEST JACKSON BOULEVARD
CHICAGO, ILLINOIS 60604

Compliance Evaluation Inspection Report

Date of Inspection: June 21, 2016

Facility Name: Seville Flexpack Corporation

Facility Address: Plant 1
9905 South Ridgeview Drive
Oak Creek, Wisconsin 53154

Plant 2
9941 South Ridgeview Drive
Oak Creek, Wisconsin 53154

EPA RCRA ID Number: WID091783647 (Both Plant 1 and 2)

Generator Status: Large Quantity Generator

Facility Contact: Dave Graf – Director of Operations

EPA Representative: Brenda Whitney – Environmental Engineer
RCRA Branch
Compliance Section 2
Land and Chemicals Division

Prepared By:


Brenda Whitney – Environmental Engineer

8-2-16
Date

Approved By:


Julie Morris – Chief, Compliance Section 2

8/2/16
Date

Purpose of the Inspection

On June 21, 2016, I conducted an unannounced Compliance Evaluation Inspection (CEI) at Seville Flexpack Corporation (“Seville” or “Facility”), located at 9905 South Ridgeview Drive in Oak Creek, Wisconsin. Seville has notified as a large quantity generator (LQG). The CEI was an evaluation of Seville’s compliance with LQG hazardous waste regulations codified at the authorized Wisconsin Administrative Code and the Code of Federal Regulations. Dolores Hayden of the Wisconsin Department of Natural Resources was unable to participate in this CEI.

Participants

The following people were present for part or all of this inspection:

Dave Graf – Director of Operations	Seville
Michael Sullivan – Director Corporate Administration	Seville
Andy Drzewiecki – Marketing Associate	Seville
Brenda Whitney – Environmental Engineer	EPA

Introduction

I arrived at the site at 8:00 am. The receptionist contacted Mr. Sullivan who met me by the front offices. I displayed my credentials, and we moved to a conference room where we could discuss the inspection. Mr. Sullivan contacted Messers. Graf and Drzewiecki who joined us in the conference room. I provided three informational handouts to Mr. Sullivan: *SHWEC Environmental Programs (WDNR brochure)*; *P2 Technical Assistance Contacts*; and *U.S. EPA Small Business Resources*. I also informed the Seville representatives that I would be taking photographs during the CEI as needed. We discussed Seville’s history, manufacturing processes, waste generation sources, and waste management procedures before departing on the tour.

Site Description

The following information about Seville is based on the personal observations of the EPA inspector and on representations made during the inspection by the Facility personnel identified above or within the text.

Facility Background Information:

- Seville is a single family-owned company under the Yacich Family Children, LLC Trust.
- Seville is split into two buildings; Plant 1 and Plant 2.
- Plant 1 (North) was built in 1978; Plant 2 (South) was built in 2007. Seville has been the only occupant in these facilities.
- Plant 1 area = 104,000 ft²; Plant 2 area = 70,000 ft².
- Approximately 35 people are employed at Seville.
- The facility runs either one or two shifts, plus occasional weekends depending on workload.

Process Information:

- Seville is a converter of pharmaceutical and food-grade flexographic packaging which includes printing, laminating, and slitting processes.
 - Three flexographic printers, one rotogravure printer, and one laminator were considered operational. However, both flexographic printers and the laminator in Plant 1 were in shut down mode at the time of the inspection.
 - Seville can create multi-layer webs. Three layers is typical.
- Raw materials used are as follows:
 - Multiple web structures: typically paper, polyester, and polypropylene;
 - Pigments and solvents (two alcohols, two acetates) for mixing inks on site;
 - Pre-made solvent-based inks;
 - Solvent-based adhesives; and
 - One ammonia/water-based cold seal.

Waste Generation and Management:

- Both Plants 1 and 2 use distillation to recover solvent from spent inks. Still bottoms generated are managed as hazardous waste. This waste stream accounts for approximately 90% of the hazardous waste generated at the Facility.
- The distillation unit in Plant 1 is a small batch unit with a built in 300-gallon storage vessel. This unit is not connected to the process lines. Flushed waste must be manually brought to the unit and pumped into the storage vessel with a mobile pneumatic air pump. This distillation unit is run every other day to once a week.
- The distillation unit in Plant 2 is a larger operation with a separate storage tank. This unit is hard piped to the process lines and has automatic feed and shut off systems.
- Plants 1 and 2 have parts washer units.
- The Plant 1 parts washer is for components that are disassembled from the line and placed into the top of the unit.
- The Plant 2 parts washer is larger and accepts carts of components that are rolled into the unit.
- Process tanks and equipment are cleaned with 100% reclaimed solvent. Reclaim is used solely in-house. Virgin solvents are used only for thinning ink.
- Adhesive wastes are cleaned manually because they are difficult to remove once hardened. This waste is not reclaimed and is sent directly off-site as hazardous waste. This waste stream accounts for approximately 10% of the hazardous waste generated at the Facility.
- Used rags are generated from cleaning. These rags are laundered.
- Used oil is generated from maintenance of fork lifts. An outside contractor manages compressors.
- Universal waste lamps are shipped off-site once a year.
- Plant 1 (the entire facility) is under vacuum pressure to a regenerative thermal oxidizer (RTO). The presses themselves in Plant 2 are routed to the RTO at that Facility. In both cases, solvents captured in the system are used for start-up.
- The laboratories on-site are used for print inspection. Wet chemistry is not conducted in these labs.

Site Tour

The tour began in Plant 1 (North). The equipment was not running at that time. Waste was not stored in the process areas with the exception of rags that were to be laundered. One rag bin was not labeled (See Appendix A: Photograph 1). I observed the warehouse for finished goods, recyclable material storage, and packaging. Mr. Graf noted that the trim from slitting is landfilled. He stated that it is increasingly difficult to find outlets for scrap web because the layering includes materials that are not conducive to recycling.

The Plant 1 laboratory was used for physical testing such as tensile strength and checking the efficacy of the heat sealing. Hazardous waste was not observed in this laboratory. Mr. Graf explained the operation of the flexographic printer. Printing involves a rubber roll, an anilox cylinder, and a plate cylinder. A pan of ink is underneath the rubber roll, which transfers the ink to the anilox. An anilox is a metal cylinder dimpled with millions of cells and is used to provide a measured amount of ink to the printing plate. The image on the printing plate is raised in relief. The inked printing plate transfers an image to the web. Each color has its own pan and rollers. Up to six colors can be printed at the presses in Plant 1. The presses in Plant 2 can print up to eight and eleven, respectively.

Mr. Graf then showed where and how waste would be generated from cleaning one of the presses. First, the unused ink pulled out of the system is tested for viscosity with a Zahn Cup to determine if it can be reused. After that determination is made, the attachments for the ink pumps which deliver the ink to the press decks are cleaned in the parts washers. The hoses are flushed press-side, and the cylinders are cleaned by hand. The waste is collected in 5-gallon transfer buckets. The buckets are emptied into a 55-gallon drum by the distillation unit. I did not observe any of these buckets because the system was not operating at the time of the inspection. I noted to Mr. Graf that containers used to collect waste at press-side would be satellite accumulation containers.

The inspection proceeded to the distillation and parts washer room. Two 55-gallon drums were in this area. The first drum was marked only as "Dirty Solvent" and the second drum was marked only as "Ink Waste" (See Appendix A: Photographs 2 and 3). The ink waste has more solids in it (approximately 50%). It was not determined during the inspection if both containers were to be processed in the distillation unit or just the dirty solvent. These drums were not marked with start dates of accumulation nor with the words "Hazardous Waste."

Next to the distillation room was the ink storage area. A library of small containers of specialty inks were kept on racks in this area. According to Mr. Graf, ink can last for nearly ever, provided the containers are closed properly. In the rear of the ink room was the designated 90-day hazardous waste storage area (HWSA). One 55-gallon drum of "Waste Adhesive" was in this area. The container was also labeled as "Hazardous Waste," marked with the D001/F003 waste numbers, and marked with the 6-17-16 start date of accumulation.

The tour continued to Plant 2 (South). Plant 2 runs one flexographic printer and one rotogravure printer. Mr. Graf explained that rotogravure uses one cylinder, onto which the image to be transferred is engraved into the face of the cylinder rather than raised in relief as in flexographic printing. The cylinder is in direct contact with the ink tray. A blade is used to remove the excess

ink from the roller and ensures the engraving is filled with ink. The image is directly transferred from that roller to the web.

The printing lines in Plant 2 are hard-piped to the distillation solvent recovery system. When the job is completed, a computer is used to start and run the flush system. Nothing on these lines is manually cleaned in this plant. Reclaimed solvent is pumped from the distillation room to each deck in an enclosed pressurized blade system. When the process is complete, the dirty solvent is pumped back to the dirty solvent tank. Mr. Graf stated that the system is completely closed loop, and that only still bottoms are removed from the system. Attachments to the ink pumps are cleaned in the parts washer.

Near the printing lines, I observed another bin for used rags that were to be laundered. This bin as labeled as "Dirty" (See Appendix A: Photograph 5).

Containers of waste were held in the 90-day HWSA in the distillation room (See Appendix A: Photograph 7). Five 55-gallon drums of still bottoms were located in this area. Each drum was labeled as "Hazardous Waste," was closed and marked with D001/F003 waste numbers. The earliest start date on these containers was from 5/25/16. One drum of "Ink Waste" was marked with the 5-10-16 start date of accumulation. This container was not marked with the words "Hazardous Waste." It was not determined during the inspection if this waste was going to be distilled. Two additional 55-gallon drums of "Dirty Solvent" were to be distilled. These containers were not marked as "Hazardous Waste" nor marked with start dates of accumulation. One drum of "Adhesive Waste" was still being filled. This container was not at or near the point of generation, was marked with the start date of accumulation from 6-13-16, and was not marked with the words "Hazardous Waste." Additionally, containers of waste cold seal were stored in this area. This material is water and ammonia-based.

The distillation system itself consisted of a storage tank and distillation column. The storage tank was not marked with the words "Hazardous Waste" and is not managed as a hazardous waste unit (See Appendix A: Photograph 6). I did not see any Subpart BB identification tags on any of the equipment associated with this distillation system. The building was serving as a secondary containment system for the tank. A sump in the floor near the system was blind and was to be used as containment (See Appendix A: Photographs 8 and 9).

The ink and raw material storage area were in the warehouse room next to the distillation unit. Hazardous waste was not observed in this area.

The inspection doubled back to the warehouse of Plant 1. Six boxes of universal waste lamps were stored in this warehouse. All containers were dated within one year of the inspection. The containers were marked as "Bad Bulbs" and were closed.

End of tour.

Records and Emergency Preparedness Review

Preparedness and Prevention: Aisle space appeared adequate in the facility and in the 90-day HWSAs. Emergency equipment was available in and or near 90-day HWSAs and is inspected on a set schedule. Arrangements with state and local emergency responders have been made with the exception of a spill response contractor. CHEMTREC is listed as an emergency contact on the hazardous waste manifests.

Contingency Plan: The contingency plan was available for review and was last updated on 11-4-15. Emergency coordinators were up to date, were listed in primary-alternate order, and included phone numbers, addresses, and responsibilities. The facility map in the plan includes evacuation information, signals, and routes. A list of emergency equipment with descriptions and locations was also included. Emergency responder contact information was listed including state and federal agencies. The plan states that coordination agreements have been made with those responders. The local hospital has been offered the contingency plan. The fire department and police department are notified through the Wisconsin Emergency and Hazardous Chemical Inventory System.

Training: RCRA-based training has not been conducted at the Facility in at least three years. Walt Ebersohl of the WDNR had provided compliance assistance in putting together a training program for this Facility during his last inspection. Because of the low turn-over of employees at this Facility, the decision was made that training did not need to be provided every year. Mr. Graf did state that the employees that physically manage hazardous waste are provided with training. It did not appear that employees who serve as the emergency coordinators were also included in the training program. Mr. Graf and Mr. Sullivan are the trainers. It was not made clear during the inspection what training Mr. Graf and Mr. Sullivan had received themselves.

Job descriptions were not available for review.

Manifests: Manifest records for at least three years were available for review. The final-signed copy of the manifests were available for review at that time. Corresponding land disposal restriction forms were also available for review. From the LDR forms that I reviewed, it appeared that underlying hazardous constituents were determined to be "None."

Universal waste was last shipped off-site through LB Medwaste Services on 1-27-16.

Inspections: Weekly inspections of the designated 90-day storage areas appeared to be conducted consistently and records were available for review for at least three years. Inspections were not being conducted for the drums of waste stored by the distillation unit in Plant 1.

Tank Requirements: Seville does not manage the tank which stores waste solvent prior to distillation in Plant 2 as a hazardous waste tank. Records including, but not limited to tank assessments and inspection logs, to support the requirements of 40 CFR subpart J were not available for review.

Air Emissions Requirements: Seville is a synthetic minor sources of emissions generating under 25 tons of emissions annually. Seville operates under a WDNR-issued ROP-A air permit. This license is generic and does not supplant RCRA air emissions requirements.

Seville does not believe they are subject to 40 CFR 265 subparts AA/BB/CC for air emissions. Records to support the requirements of these subparts were not available for review.

Closing Conference

During the closing conference with the Seville representatives, I discussed my observations noted during the inspection and asked some outstanding questions from the inspection checklists. I informed them that I would be generating a report that included a letter, narrative discussion of the CEI and attendant photographs and checklists. Any response needed from Seville according to the letter would be expected within 30 days.

The following items were discussed with Seville personnel at the close of the inspection.

- Information discussed and collected throughout the inspection was not claimed as confidential business information;
- Satellite and 90-day storage requirements;
- Tank system and air emissions requirements;
- Universal waste requirements;
- Training record requirements;
- Contingency plan requirements;
- Closed loop exemption;

Appendices

Appendix A: Photograph Log

Appendix B: Checklists

Appendix C: Documents received during the CEI

Appendix A

Photograph Log

Inspection Date:

June 21, 2016

Facility Name and ID Number:

Seville Flexpack Corporation

EPA ID: WID091783647

Inspector and Photographer:

Brenda Whitney

Compliance Section 2

RCRA Branch

Land and Chemicals Division

Camera Used:

Olympus Stylus 600

Serial Number: A47525904

Photograph 1

Taken at 9:31 a.m..CST

A bin of rags destined for laundering located near the print lines in Plant 1 was not marked.



Photograph 2

Taken at 9:37 a.m. CST

One 55-gallon drum in the distillation room was marked only as "Dirty Solvent." This material was to be recycled in the distillation unit.



Photograph 3

Taken at 9:37 a.m. CST

This 55-gallon drum marked only as "Ink Waste" was located in the distillation room. This waste may have been destined for the distillation unit.



Photograph 4

Taken at 9:45 a.m. CST

This container is used to collect still bottoms from the distillation unit. The container was empty at the time of the inspection.



Photograph 5

Taken at 9:59 a.m. CST

A bin of rags in Plant 2 was labeled as "Dirty."



Photograph 6

Taken at 10:09 a.m. CST

The dirty solvent tank in Plant 2 was not labeled as "Hazardous Waste" and did not appear to have its own containment system. The floor appeared to have been coated and sloped toward a blind sump. (See photographs 8 and 9 for the sump grate). The piping and equipment leading to and from this tank were not identified with Subpart BB tags.



Photograph 7

Taken at 10:22 a.m. CST

These containers were located in the 90-day HWSA in Plant 2. The drums on casters were to be distilled. The fiberboard drum held the non-hazardous water/ammonia based cold seal.



Photograph 8

Taken at 10:25 a.m. CST

This photograph was an attempt to show the interior of the blind sump that is located in the Plant 2 HWSA. This sump is to be used as containment for the distillation system and storage tank.



Photograph 9

Taken at 10:25 a.m. CST

The photograph shows the grate for the sump identified in Photograph 8. See Photograph 8 for additional description.



Photograph 10

Taken at 10:34 a.m. CST

This RTO is associated with Plant 1.



Photograph 11

Taken at 10:36 a.m. CST

This RTO is associated with Plant 2.



Appendix B

Checklists

Inspection Date:

June 21, 2016

Facility Name and ID Number:

Seville Flexpack Corporation

EPA ID: WID091783647

Inspector:

Brenda Whitney

Compliance Section 2

RCRA Branch

Land and Chemicals Division

LARGE QUANTITY GENERATOR INSPECTION



This inspection form, used for the inspection of facilities that generate over 1000 kg (2205 lbs) of non acute hazardous waste in a calendar month or over 1 kg of acute hazardous waste in a calendar month, evaluates compliance with Wisconsin's Hazardous Waste Management Rules (chapter NR 600-679, Wis. Admin. Code).

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WISCONSIN DEPARTMENT OF ENVIRONMENTAL PROTECTION
HAZARDOUS WASTE MANAGEMENT PROGRAM

Section 1: Waste Information

A. Hazardous waste determination has been made on each solid waste generated.	Y	662.011
B. Waste determination was made correctly, considering the listed waste definitions and the characteristics of the waste, in light of the materials or processes used.	Y	662.011(3)
C. Waste samples are analyzed by laboratories certified or registered under NR 149. Provide lab names and certification numbers.	Y	662.011(3)(a)1
D. Generator keeps records of all waste determinations on-site for at least three years from the date the waste was last sent to a storage, treatment or disposal facility.	Y	662.040(3)
E. Generator submitted a notification form and obtained an EPA ID#.	Y	662.012

Note: A subsequent notification should be submitted when there is an ownership or name change.

Section 2: Manifest, Pre-Transport Requirements and Off-Site Shipments

A. Copy of the manifest with all off-site shipments of hazardous waste.	Y	662.020(1)
B. The manifest is used according to the instructions in the appendix to 40 CFR part 262.	Y	662.020(1)
C. The facility designated on the manifest is permitted or licensed to accept the waste.	Y	662.020(2)
D. For out-of-state shipments, a copy of the manifest is sent to the department within 30 days of receiving the signed copy from the designated facility.	N	662.023(3)
E. Manifest continuation form, EPA form 8700-22A, is prepared according to the instructions in the appendix of 40 CFR part 262.	N	662.020(1)
F. If the generator received a shipment back as a rejected load, the returned waste was accumulated in compliance with the container or tank standards for less than 90 days.	N	662.034(13)
G. Upon receipt of the rejected shipment, the generator signed EITHER of the following: 1. Manifest Item 18c if the transporter returned the shipment using the original manifest. 2. Manifest Item 20 if the transporter returned the shipment using a new manifest.	N	662.034(13)
H. A copy of the manifest signed by the generator is retained until the signed copy from the designated facility is received.	Y	662.040(1)
I. Copy of each manifest is kept for at least three years from the date of shipment.	Y	662.040(1)
J. Hazardous waste is packaged according to applicable DOT requirements before transport.	Y	662.030
K. Hazardous waste is labeled according to applicable DOT requirements before transport.	Y	662.031



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Section 2: Manifest, Pre-Transport Requirements and Off-Site Shipments

L. Hazardous waste is marked according to applicable DOT requirements before transport.	Y	662.032(1)
M. Containers of 119 gallons and less are marked with the "Hazardous Waste-Federal law prohibit improper disposal" label before transport.	N/A	662.032(2)
N. Placards are offered to the initial transporter.	Y	662.033

Section 3: Land Disposal Restrictions

A. Generator determined if each waste is prohibited from land disposal by lab analysis or generator knowledge.	Y	668.07(1)
B. A copy of the LDR notification and certification for solid wastes even when the hazardous characteristic is removed prior to disposal, or when the waste is excluded from the definition of hazardous or solid waste under ss. NR 661.02 to 661.06, or exempted from ch. 291, Stats., and chs. NR 660 to 673, subsequent to the point of generation.	Y	668.07(1)(h)
C. Generator complies with the prohibition against dilution of wastes.	Y	668.03
D. A one-time written notice was sent to each treatment, storage or disposal facility with the initial waste shipment.	Y	668.07(1)
E. A new notification is sent to the TSD and maintained in the generator file when the waste or receiving facility changes.	Y	668.07(1)
F. If the waste MEETS treatment standards, the LDR notice certifies wastes may be land disposed without further treatment.	N	668.07(1)
G. If the waste EXCEEDS treatment standards, the LDR notice gives notification of appropriate treatment and applicable prohibitions.	Y	668.07(1)
H. A copy of the LDR notifications and certifications are retained for at least 3 years from the date the waste was last sent off-site.	Y	668.07(1)(h)
I. Underlying hazardous constituents have been identified for characteristic wastes.	N	668.09(1)
J. Generator identifies EITHER of the following when the waste is both a listed and characteristic waste: 1. The treatment standards for the listed waste code, in lieu of the treatment standard for the characteristic waste codes. 2. The treatment standards for all applicable listed and characteristic waste codes. K. If waste is treated in containers or tanks, the generator meets BOTH of the following (NR 668.07(1)(e)). 1. Developed a written waste analysis plan describing the procedures used to meet applicable LDR treatment standards. 2. Complies with the certification requirements in NR 668.07(1)(c).	Y	668.09(2) 662.034(1)(c)

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Section 4: Annual Reports and Exception Reporting

A. Annual reports covering generator activities during the calendar year have been submitted to the Department by March 1 of the following year.	Y	662.041
B. Transporter or TSD is contacted if signed manifest is not received in 35 days.	Y	662.042(1)
C. Exception report is submitted to the Department if a signed manifest is not received within 45 days.	NA	662.042(2)
D. Copy of each annual report and exception report is kept for at least 3 years from the date of the report.	Y	662.040(2)

Section 5: Preparedness and Prevention

A. Generator has ALL of the following, unless the equipment is not necessary for the types of wastes handled (NR 665.0032): 1. Device to summon emergency assistance (e.g., telephone, 2 way radio). 2. Internal communications and alarm systems. 3. Portable fire extinguishers. 4. Fire control equipment, including special extinguishing equipment. 5. Spill control equipment. 6. Decontamination equipment (e.g., eyewash, shower). 7. Water at adequate volume and pressure to supply water spray systems.	Y	662.034(1)(d)
B. All of the above emergency equipment is tested and maintained to assure its proper operation in an emergency (NR 665.0033).	Y	662.034(1)(d)
C. There is immediate access to internal or external alarms or an emergency communication device in hazardous waste handling areas (NR 665.0034).	Y	662.034(1)(d)
D. Generator has made ALL of the following arrangements with emergency organizations (NR 665.0037): 1. Primary and support roles have been defined if multiple police and fire departments could respond to an emergency. 2. Police, fire and emergency response teams are familiar with the site layout, hazards of the waste handled, places where personnel work, entrances and roads in the site and possible evacuation routes. 3. Agreements are made with emergency response contractors and equipment suppliers. 4. Local hospitals are familiar with the properties of wastes handled and the types of injuries or illnesses that could result from an emergency.	N	662.034(1)(d)
E. Aisle space provided throughout the facility to allow for the unobstructed movement of personnel and all emergency equipment (NR 665.0035).	Y	662.034(1)(d)

Section 6: Contingency Plan and Emergency Procedures

A. Generator has a written contingency plan, amended SPCC plan or other emergency plan that will be implemented immediately in the event of a fire, explosion or hazardous waste discharge (NR 665.0051). If there is no written plan go to question 7.A.	Y	662.034(1)(d)
B. Generator has amended a SPCC plan or other emergency plan so it sufficiently incorporates hazardous waste management provisions (NR 665.0052(2)).	NA	662.034(1)(d)



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Section 6: Contingency Plan and Emergency Procedures

C. Copies of the contingency plan and all revisions have been made available to police, fire, hospital and emergency response teams. (NR 665.0053(2)).	N	662.034(1)(d)
D. Contingency plan was amended due to ANY of the following (NR 665.0054): 1. Contingency plan failed in an emergency. 2. Change in site design, construction, O&M, or other circumstances which affect emergency response. 3. Emergency coordinators changed. 4. Emergency equipment changed.	NA	662.034(1)(d)
E. Contingency plan identifies an emergency coordinator who meets ALL of the following (NR 665.0055): 1. Available or on call to coordinate emergency response measures. 2. Familiar with all aspects of site activities and the contingency plan. 3. Has authority to commit the resources needed to carry out the contingency plan.	Y	662.034(1)(d)
F. Contingency plan includes ALL of the following (NR 665.0052): 1. Designation of the primary emergency coordinator, with alternates listed in the order of assuming responsibility. 2. Name, address and phone number, office and home, for each emergency coordinator. 3. Description of the arrangements agreed to by the police, fire, hospitals and emergency response teams to coordinate emergency services. 4. Evacuation plan for personnel including signal(s) to be used in the event of evacuation and alternate routes. 5. Actions facility personnel will take in response to a fire, explosion, or hazardous waste discharge. 6. List of emergency equipment at the site, including location, description and capabilities of each item.	Y	662.034(1)(d)
G. Contingency plan requires the emergency coordinator to do ALL of the following in the event of a fire, explosion, or discharge of hazardous wastes (NR 665.0056): 1. Activate internal alarms or communication systems. 2. Notify appropriate authorities, if their help is needed. 3. Identify the character, source, amount, and extent of discharged hazardous materials. 4. Assess hazards to human health and the environment. 5. If the incident threatens human health or the environment outside the facility, notify local authorities that evacuation may be necessary and notify the national response center (800-424-8802) and the division of emergency government (800-943-0003). 6. Take all reasonable measures necessary to ensure fires, explosions and discharges do not occur, reoccur, or spread. 7. Monitor for leaks, pressure buildup, gas generation or ruptures in valves, pipes, or other equipment if the site stops operation. 8. Provide for treating, storing, or disposing of recovered waste, contaminated soil, surface water, or other material. 9. Ensure wastes that are incompatible with the released material are not treated, stored or disposed until cleanup is completed. 10. Ensure that emergency equipment is clean and fit for use prior to resuming operations. 11. Notify the department and appropriate state and local authorities before resuming operations. 12. Submit an incident report to the department within 15 days.	Y	662.034(1)(d)

Section 7: Personnel Training Requirements

A. Generator has a program of classroom instruction or on-the-job training for personnel in hazardous waste management (NR 665.0016(1)(a)). If there is no training program go to question 8.A.	Y	662.034(1)(d)
B. Program is directed by a person trained in hazardous waste management procedures (NR 665.0016(1)(b)).	N	662.034(1)(d)



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Section 7: Personnel Training Requirements

C. Program teaches facility personnel hazardous waste management procedures relevant to the positions in which they are employed (NR 665.0016(1)(b)).	Y	662.034(1)(d)
D. Training program ensures personnel are able to respond effectively to emergencies by familiarizing them with the following applicable items (NR 665.0016(1)(c)):	N	662.034(1)(d)
1. Contingency plan implementation.		
2. Procedures for using, inspecting, repairing, and replacing emergency and monitoring equipment.		
3. Key parameters for automatic waste feed cut-off systems.		
4. Communications and alarm systems.		
5. Response to fires or explosions.		
6. Response to groundwater contamination incidents.		
7. Shutdown of operations.		
E. New employees are trained within 6 months of their assignment (NR 665.0016(2)).	NI	662.034(1)(d)
F. Employees work in supervised positions until they have completed the training (NR 665.0016(2)).	NI	662.034(1)(d)
G. Personnel take part in an annual review of the training (NR 665.0016(3)).	Y	662.034(1)(d)
H. Generator keeps ALL of the following training documents (NR 665.0016(4)):	N	662.034(1)(d)
1. Job title and the employee name for each position related to hazardous waste management.		
2. Job description for each of the above job titles.		
3. Description of the amount and type of introductory and continuing training that will be given to each employee.		
4. Records that required training has been given to each employee.		
I. Training records are maintained until closure for current personnel and at least 3 years from the date the employee last worked at the facility (NR 665.0016(5)).	N	662.034(1)(d)

Section 8: 90-Day Container Accumulation

A. Waste is accumulated in containers. If NO, go to Section 9.	Y	
B. Accumulation start date is clearly marked and visible for inspection on each container.	N	662.034(1)(b)
C. All containers are clearly marked with the words "Hazardous Waste".	N	662.034(1)(c)
D. If container is leaking or in poor condition, the contents are transferred to another container in good condition (NR 665.0171).	NA	662.034(1)(a)1
E. Containers are made of or lined with materials that are compatible with the waste (NR 665.0172).	Y	662.034(1)(a)1
F. Containers are kept closed, except when it is necessary to add or remove waste (NR 665.0173(1)).	Y	662.034(1)(a)1
G. Containers are opened, handled or stored to prevent leaks or ruptures (NR 665.0173(2)).	Y	662.034(1)(a)1



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Section 8: 90-Day Container Accumulation

H. Container storage areas are inspected weekly for leaks and deterioration (NR 665.0174).	Y	662.034(1)(a)1
I. Containers of ignitable or reactive waste are located at least 50 feet from the property line (NR 665.0176).	Y	662.034(1)(a)1
J. Containers of incompatible wastes are separated or protected from each other by a physical barrier (dike, berm, wall or other device) (NR 665.0177(3)).	NA	662.034(1)(a)1
K. Incompatible wastes are stored in separate containers unless the mixing will not generate extreme heat, fire, explosion, toxic gases or other dangers (NR 665.0177(1)).	NA	662.034(1)(a)1
L. Containers that previously held waste are properly washed before adding incompatible waste, unless the mixing will not generate extreme heat, fire, explosion, toxic gases or other dangers (NR 665.0177(2)).	NA	662.034(1)(a)1

Section 9: Subchapter BB Standards for Equipment Leaks

A. Generator operates any of the following equipment containing or contacting hazardous wastes with organic concentration $\geq 10\%$ by weight. If NO, go to Section 10 (NR 662.034(1)(a), NR 665.1050(2)).	Y	
1. Pumps in light liquid service.		
2. Compressors.		
3. Pressure relief devices in gas or vapor service.		
4. Sampling connection systems.		
5. Open-ended valves or lines.		
6. Valves in gas or vapor service or in light liquid service.		
7. Pumps or valves in heavy liquid service.		
8. Pressure relief devices in light liquid or heavy liquid service.		
9. Flanges or other connectors.		
B. Equipment listed in Question 9.A. is excluded from subch. BB requirements because it is in vacuum service and individually listed in the facility operating record by an identification number (NR 665.1050(4), NR 665.1064(7)(a)).	ND	662.034(1)(a)
C. Equipment listed in Question 9.A. is excluded from subch. BB requirements because it operates < 300 hours per calendar year and is identified, either by list or location (area or group), in the facility operating record. (NR 665.1050(5), NR 665.1064(7)(f)).	N	662.034(1)(a)
D. If the facility determines compliance with subch. BB by documenting compliance with Clean Air Act requirements, the documentation is readily available as part of the operating record (NR 665.1064(13)).	NA	662.034(1)(a)
E. ALL of the following information used to determine the applicability of exclusions in Questions 9.B. - 9.D. is maintained at the facility (NR 665.1064(11)):	N	662.034(1)(a)
1. Analysis determining the design capacity of the hazardous waste management unit.		
2. Statement listing the hazardous waste influent to and effluent from each hazardous waste management unit subject to subch. BB and an analysis determining whether these hazardous wastes are heavy liquids.		
3. Up-to-date analysis and the supporting information used to determine whether or not equipment is subject to subch. BB.		
F. When knowledge of the nature of the hazardous waste stream or the process by which it was produced is used to determine the applicability of the exclusions, supporting documentation such as the following are maintained at the facility (NR 665.1064(11)):	NA	662.034(1)(a)
1. Information that the production process does not use organic compounds.		
2. The process is identical to a process at another facility where the total organic content was measured at $< 10\%$.		
3. The process has not changed to affect the total organic concentration of the waste.		



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Section 9: Subchapter BB Standards for Equipment Leaks

G. The facility keeps records of new determinations performed when there are any changes that could result in an increase in the total organic content of the waste in contact with equipment that is not subject to subch. BB requirements (NR 665.1064(1)).

NA 662.034(1)(a)

H. All equipment stated in Question 9.A. is excluded from additional subch. BB requirements. If NO, complete the subch. BB inspection form.

NA

No PROGRAM

Section 10: Subchapter CC Level 1 Container Standards

A. The facility manages hazardous waste in containers with EITHER of the following design capacities. If NO, go to Question 11.A. (NR 665.1087(2)(a), NR 662.034(1)(a)1).

Y

1. Between 26 and 119 gallons.

2. Greater than 119 gallons and not in light material service.

B. Containers are exempt from CC regulation because of ALL of the following (NR 662.034(1)(a)1, NR 665.1083(3)(a), NR 665.1084(1)(a)1, NR 665.1083(3)(a), NR 665.1084(1)(a)2, NR 665.1084(1)(b)):

No

1. The average VO concentration at the point of origination is <500 ppmw for all hazardous waste entering the container.

2. The initial determination of the average VO concentration for the waste stream was made before the material was placed in the container.

3. The initial determination is reviewed and updated at least once every 12 months.

4. A new waste determination is performed whenever changes to the source generating the waste stream likely causes the average VO concentration to increase to >= 500 ppmw.

5. The average VO concentration is determined by direct measurement or by knowledge. Note: See NR 665.1084(1)(c) for direct measurement procedures and NR 665.1084(1)(d) for using knowledge.

C. For each waste determination, the date, time, and location of each waste sample collected are maintained in the facility records (NR 665.1090(6)(a)).

NA 662.034(1)(a)1

D. Containers are excluded from subch. CC because they are used to store or treat hazardous waste from organic peroxide manufacturing processes (NR 662.034(1)(a)1, NR 665.1080(4)).

N

Note: Certain records are to be maintained. Refer to 665.1090(9) for more information.

E. Containers are excluded from subch. CC because they are used solely to store or treat EITHER of the following (NR 662.034(1)(a)1, NR 665.1080(2), NR 665.1090(10)):

N

1. On-site remediation wastes generated through NR 700 or RCRA corrective action activities.

2. Radioactive mixed wastes in accordance with NRC requirements

F. Containers are excluded from subch. CC because BOTH of the following are met (NR 665.1080(2), NR 665.1090(10)):

N

1. They are equipped with air emission controls operated in accordance with the Clean Air Act requirements.

2. Facility records include certification of such by the owner or operator and the specific air program compliance requirements for the containers

G. All containers are excluded from subch. CC Level 1 standards. If YES, go to Section 11.

N

H. Any of the following controls are used on all Level 1 containers (NR 665.1087(3)(a)):

Y 662.034(1)(a)1

1. Container meets applicable US DOT packaging requirements.

2. A cover and closure devices form a continuous barrier over the container openings such that when they are secured, there are no visible holes, gaps or other open spaces into the container.

3. An organic-vapor suppressing barrier is placed on or over the hazardous waste in an open-top container so that the hazardous waste is not exposed to the atmosphere.

Note: Level 1 standards do not apply to satellite accumulation or RCRA empty containers.



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Section 10: Subchapter CC Level 1 Container Standards

I. If Level 1 containers do not meet applicable US DOT packaging requirements, they are equipped with covers and closure devices composed of suitable materials that minimize exposure of hazardous waste to the atmosphere and maintain integrity of the covers and closure devices (NR 665.1087(3)(b)).

NA 662.034(1)(a)1

J. If a Level 1 container is filled to the final level in one continuous operation, the closure device is promptly secured in the closed position when the filling operation is concluded (NR 665.1087(3)(c)1.a).

Y 662.034(1)(a)1

K. If a Level 1 container is batch filled, the closure device is promptly secured in a closed position when the container is filled to the intended final level OR the batch loading is completed and any of the following first occurs (NR 665.1087(3)(c)1.b):

Y 662.034(1)(a)1

1. No additional material will be added within 15 minutes.

2. The person performing the loading operation leaves the immediate vicinity of the container.

3. The process generating the waste shuts down.

L. If a Level 1 container is opened to remove hazardous waste, the closure device is secured in the closed position upon completion of a batch removal AND when either of the following first occurs (NR 665.1087(3)(c)2b):

NA 662.034(1)(a)1

1. No additional materials will be removed within 15 minutes.

2. The person removing the waste leaves the immediate vicinity of the container.

M. If access to the inside of a Level 1 container is needed to perform routine activities other than the transfer of hazardous waste (e.g., sampling), the closure device is secured in the closed position promptly after completing the activity (NR 665.1087(3)(c)3).

NA 662.034(1)(a)1

N. If a Level 1 container is equipped with a pressure relief device that vents to the atmosphere, ALL of the following conditions are met (NR 665.1087(3)(c)4):

NA 662.034(1)(a)1

1. The device is designed to operate with no detectable organic emissions (< 500 ppmv) when in the closed position.

2. The device is closed when the internal pressure is within the specified operating range.

3. The device opens and vents to the atmosphere only for the purpose of maintaining internal pressure according to the design specifications.

O. Safety valves are only opened to avoid an unsafe condition (NR 665.1087(3)(c)5).

NA 662.034(1)(a)1

P. When a defect is detected, initial repair efforts are made within 24 hours of detection and completed within 5 calendar days (NR 665.1087(3)(d)3).

NA 662.034(1)(a)1

Q. If repairs cannot be completed in 5 days of detecting the defect, the waste is removed from the container which is not used until it is repaired (NR 665.1087(3)(d)3).

NA 662.034(1)(a)1

Section 11: Subchapter CC Level 2 Container Standards

A. The facility manages hazardous waste containers with a design capacity >119 gallons that are in light material service. If NO, go to Section 12.

NA

B. Any of the following controls are used on Level 2 containers: (NR 665.1087(4)(a))

662.034(1)(a)2

1. Container meets applicable US DOT packaging requirements.

2. Each potential leak interface where organic vapor leakage could occur on the container, cover and closure device has been checked to determine that no detectable organic emissions (< 500 ppmv) are occurring.

3. The facility has demonstrated within the last 12 months that the containers are vapor-tight using Method 27 in appendix A of 40 CFR part 60.



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Section 11: Subchapter CC Level 2 Container Standards

C. If the potential leak interface on the containers were checked, BOTH of the following were met: (NR 665.1087(4)(a))
1. Checks were made on the interface of the cover rim and the container wall; the periphery of any opening on the container or container cover and its associated closure device; and, the sealing seat interface on a spring-loaded, pressure-relief valve.
2. The test was performed when the container was filled with a material having a VO concentration representative of the hazardous waste expected to be stored in the container.
D. The facility maintains a copy of the procedure used to determine that containers >119 gallons in size that do not meet DOT requirements are not managing hazardous waste in light material service. (NR 665.1087(3)(e))

NA 662.034(1)(a)2

E. Level 2 controls are used when transferring waste in or out of the container that minimize exposure to the atmosphere (submerged-fill pipe, vapor-recovery system, etc.) to the extent practical, considering the physical properties of the hazardous waste and good engineering and safety practices. (NR 665.1087(4)(b))

662.034(1)(a)2

F. If the container is filled to the final level in one continuous operation, the closure devices are promptly secured in the closed position when the filling operation is concluded. (NR 665.1087(4)(c)1.a.)

662.034(1)(a)2

G. If the container is batch filled, the closure devices are promptly secured in a closed position upon filling the container to the intended final level, or when the batch loading is completed and ANY of the following first occurs: (NR 665.1087(4)(c)1.b.)

662.034(1)(a)2

1. No additional material will be added within 15 minutes.
2. The person performing the loading operation leaves the immediate vicinity of the container.
3. The process generating the waste shuts down.

H. If containers are opened to remove hazardous waste, closure devices are secured in the closed position upon completion of a batch removal and either of the following first occurs: (NR 665.1087(4)(c)2.b.)

662.034(1)(a)2

1. No additional materials will be removed within 15 minutes.
2. The person removing the waste leaves the immediate vicinity of the container.

I. If access to the inside of the container is needed to perform routine activities other than the transfer of hazardous waste (e.g., sampling), the closure device is secured in the closed position promptly after completing the activity. (NR 665.1087(4)(c)3.)

662.034(1)(a)2

J. If the container is equipped with a pressure relief device that vents to the atmosphere, the device meets ALL of the following conditions: (NR 665.1087(4)(c)4.)

662.034(1)(a)2

1. Designed to operate with no detectable organic emissions when in the closed position.
2. Closed when the internal pressure is within the specified operating range.
3. Opens and vents to the atmosphere only for the purpose of maintaining internal pressure according to the design specifications.

K. Safety valves are only opened to avoid an unsafe condition. (NR 665.1087(4)(c)5.)

662.034(1)(a)2

L. When a defect is detected, initial repair efforts are made within 24 hours of detection. (NR 665.1087(4)(d)3.)

662.034(1)(a)2

M. Repairs are completed within 5 days, or the waste is removed from the container which is not used until the defect is repaired. (NR 665.1087(4)(d)3.)

662.034(1)(a)2

Section 12: Subchapter CC Level 3 Container Standards

A. The facility manages hazardous waste in containers having a design capacity >26 gallons during a waste stabilization process when hazardous waste is exposed to the atmosphere. If NO, go to Section 13.

NA

B. The container is vented directly through a closed-vent system to a control device, or the container is vented inside an enclosure which is exhausted through a closed-vent system to a control device. (NR 665.1087(5)(a))

662.034(1)(a)2

Code/Stat T: C: Compliance CA: Compliance with Concern R: Returned to Compliance X: Non-Compliance NA: Inspected, Not Applicable/ND: Inspected, Not Determined NI: Not Inspected
Noncode Y: Y: Yes N: No UN: Unknown

Notes: *: Dept. approved alternate may apply No "box" is an open ended question

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Section 12: Subchapter CC Level 3 Container Standards

C. If the container is vented inside an enclosure, the enclosure is operated according to the criteria for permanent total enclosures found in Method 204 in appendix M of 40 CFR part 51. (NR 665.1087(5)(b)1.)

NA 662.034(1)(a)2

D. Records for the most recent set of calculations and measurements verifying the enclosure meets the criteria for a permanent total enclosure in Method 204 in appendix M of 40 CFR part 51 are maintained at the facility. (NR 665.1090(4)(a))

662.034(1)(a)2

E. Level 3 controls are used when wastes are transferred in or out of the container that minimize exposure to the atmosphere (e.g., submerged-fill pipe, vapor-recovery system, etc.) to the extent practical, considering the physical properties of the hazardous waste and good engineering and safety practices. (NR 665.1087(5)(f))

662.034(1)(a)2

Section 13: Satellite Accumulation

A. Waste is accumulated in satellite accumulation areas. If NO, go to Section 14.

NO

B. Generator accumulates no more than 55 gallons of hazardous waste or 1 quart of acute hazardous waste in each satellite area.

662.034(3)(a)

C. Satellite containers are under the control of the operator of the process generating the waste.

662.034(3)(a)

D. Containers are made of or lined with materials that are compatible with the waste (NR 665.0172).

662.034(3)(a)1

E. If a container is leaking or in poor condition, the contents are transferred to another container in good condition (NR 665.0171).

662.034(3)(a)1

F. Containers are kept closed except when it is necessary to add or remove waste (NR 665.0173(1)).

662.034(3)(a)1

G. Containers are marked "Hazardous Waste" or with other words that identify the contents.

662.034(3)(a)2

H. Container holding the excess waste is marked with the date the excess amount begins accumulating.

662.034(3)(b)

I. Generator complies with the 90 day accumulation requirements with respect to the excess amount within 3 days of it being generated.

662.034(3)(b)

Section 14: Waste Minimization

A. Generator includes waste minimization information in the annual report.

Y 662.041(3)(e)

B. Generator has a program in place to reduce the volume or quantity and toxicity of waste to an economically practicable degree.

Y 662.027(1)

Note: The inspector should look for evidence justifying the generator's waste minimization certification on the manifest. Also, EPA guidance recommends that the generator have a written waste minimization/pollution prevention plan.

Code/Stat T: C: Compliance CA: Compliance with Concern R: Returned to Compliance X: Non-Compliance NA: Inspected, Not Applicable/ND: Inspected, Not Determined NI: Not Inspected
Noncode Y: Y: Yes N: No UN: Unknown

Notes: *: Dept. approved alternate may apply No "box" is an open ended question

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Section 15: Used Oil

A. Used oil is managed on-site. If NO, go to Section 16	None observed	
B. Used oil containing $\geq 1,000$ ppm halogens is managed as listed hazardous waste or the rebuttable presumption requirements have been met.	NA	679.10(2)(a)2
C. Used oil containers and tanks are in good condition and not leaking.	Y	679.22(2)
D. Used oil containers and tanks are marked "used oil".	Y	679.22(3)(a)
E. Transporter has an EPA ID number, except when generator self-transport or has a tolling agreement.	Y	679.24
F. If oil containing materials are disposed of as a solid waste, the used oil has been properly drained so there is no visible sign of free-flowing oil and a waste determination has been properly made.	NA	679.10(3)(a)
G. If used oil is burned in an on-site used oil-fired space heater, all of the following are met: 1. Only used oil from the generator or household do-it-yourselfers is burned. 2. The heater is designed with a maximum capacity of 0.5 million BTU per hour or less. 3. The combustion gases are vented to the ambient air.	NA	679.23
H. If used oil is accepted from others or sent off-site to be burned in a space heater, the used oil meets fuel specifications and the marketer requirements in NR 679 subch. H are met.	NA	679.11

Section 16: Universal Waste

A. The facility is a small quantity handler of universal waste (never accumulates more than 11,025 lbs). If NO, state in the comments section if the facility is a universal waste nonhandler, large handler or destination facility, and go to Section 17.	Y	
Note: If the facility is a large handler, complete the large quantity handler of universal waste inspection form.		
B. Universal waste has not been disposed, treated or diluted.	Y	673.11
Note: Dilution or treatment does not include: sorting, mixing, discharging, regenerating, or disassembling batteries; removing batteries from consumer products or removing electrolytes; removing thermostat ampules; or, responding to a release of universal waste.		
C. Universal waste batteries and thermostats that are broken or show evidence of leakage or spillage are placed in closed, structurally sound containers that are compatible with the waste and not leaking.	NA	673.13
D. Universal waste lamps and pesticides are placed in closed, structurally sound containers that are compatible with the waste and are not leaking.	Y	673.13
E. All universal wastes are labeled or marked "Waste" or "Used" followed by the specific type of universal waste handled or "Universal Waste".	Y	673.14
F. Universal waste is accumulated for less than one year from the date generated or received from another handler.	Y	673.15(1)
G. If universal waste is accumulated beyond one year, the handler can prove that accumulation was necessary to facilitate proper recovery, treatment or disposal.	NA	673.15(2)



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Section 15: Universal Waste

H. Length of accumulation time is demonstrated by any of the following: 1. Each container is marked or labeled with the earliest date the waste is generated or received. 2. The individual item of waste is marked or labeled with the date it was generated or received. 3. An inventory system identifying the date the waste was generated or received is maintained. 4. The universal waste is placed in a specific accumulation area identified with the earliest date the waste was generated or received.	Y	673.15(3)
I. Employees are trained on the proper handling and emergency procedures appropriate to the types of waste handled at the facility.	Y	673.16
J. ALL of the following are met when a release occurs: 1. Release is immediately contained. 2. A waste determination is made. 3. Spill residue is disposed of properly as solid or hazardous waste.	NA	673.17
K. Handler sends the waste to a destination facility, foreign destination or another handler. Indicate the facilities in the comments section.	Y	673.18(1)
L. For hazardous materials, the handler packages, labels, marks, placards and prepares the proper shipping papers in accordance with DOT requirements in 49 CFR parts 172 to 180.	Y	673.18(3)
M. The following activities have occurred. If YES, complete the Universal Waste Small Quantity Handler inspection form. 1. Universal waste are sorted or disassembled. 2. Recalled pesticides are managed. 3. Universal waste shipments have been rejected. 4. Universal waste shipments have included hazardous or solid waste. 5. Universal waste is self-transported.	NA	

Section 17: F006 Wastewater Treatment Sludge

A. Generator accumulates F006 sludge for more than 90 days. If NO, go to Section 18.	NA	
B. The F006 waste is accumulated for no more than 180 days, unless the waste is shipped 200 miles or more.	Y	662.034(7)
C. Pollution prevention practices are in place to reduce the amount of contaminants entering the F006 waste.	Y	662.034(7)(a)
D. The F006 waste is legitimately recycled through metals recovery.	Y	662.034(7)(b)
E. No more than 20,000 kg (44,100 lbs) of F006 waste is accumulated on-site.	Y	662.034(7)(c)
F. Accumulation containers meet subch. I, AA, BB and CC standards in ch. NR 665.	Y	662.034(7)(d)1.a
G. The accumulation start date is clearly marked and visible for inspection on each container.	Y	662.034(7)(d)3
H. Accumulation tanks meet subch. J, AA, BB and CC standards in ch. NR 665, except for NR 665.0197(3) and NR 665.0200.	Y	662.034(7)(d)1.b



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Section 17: F006 Wastewater Treatment Sludge

I. Each container and tank of F006 waste is clearly marked with the words "Hazardous Waste".	662.034(7)(d)4
J. A containment building used for accumulation meets subch. DD standards in ch. NR 665; a P.E. certification stating compliance with the design standards is in the operating record AND written procedures and documentation for emptying the unit within 180 days are on file.	662.034(7)(d)1.c
K. The accumulation of F006 waste is included in the preparedness and prevention procedures, contingency plan and personnel training program.	662.034(7)(d)5
L. If waste is accumulated for up to 270 days, the generator must ship the waste over 200 miles for metals recovery.	662.034(8)

Section 18: Generator Status Evaluation

A. Waste is accumulated for less than 90 days, except as allowed in Sections 13 and 16.	Y	662.034(1)
B. More than 2,205 lbs. of non-acute hazardous waste; 2.2 lbs. of acute hazardous waste; or, 220 lbs. of residue from cleanup of an acute hazardous waste spill is generated in any month (NR 662.190(1), NR 662.220(4)).	Y	
C. Describe other activities that the generator conducts at the facility (accumulation in tanks, recycling, 10-day transfer, transporter, used oil, treatment, storage, disposal, universal waste, etc.).		
D. If waste was previously accumulated in a tank system, the generator performed EITHER of the following (NR 665.0197(1), NR 665.0197(2)): 1. Closure by removing or decontaminating waste residues, contaminated containment system components, soils, structures and equipment. 2. Initiated long-term care if all contaminated soils cannot be practicably removed or decontaminated.	NA	662.034(1)(a)2

Accumulation in tanks prior to distillation in ^{South} plant.

Appendix C

Documents received during the Inspection:

- Two site maps
-

Inspection Date:

June 21, 2016

Facility Name and ID Number:

Seville Flexpack Corporation

EPA ID Number: WID0901783647

Inspector:

Brenda Whitney

Compliance Section 2

RCRA Branch

Land and Chemicals Division

Seville Flexpack Corporation
 9905 S. Ridgeview Drive
 Oak Creek, WI 53154

Overall Area = 104,004 Square Feet

